



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200
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D350-567-141
Job Sheet 193724



Part No: D350-567-141

Job Qty: 1 pcs ✓

Part Name: Floor Window Close Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/22/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 5/22/19

Description:

Type: Stock

Note: DSI9590 REV:G IPP REV:A 11.11.09 new issue DD verf:JLM IPP REV:B 12.01.23 AS PER ECN12-511 DD
VERF:EC IPP REV:C 12.03.05 AS PER ECN12-537 DD VERF:EC IPP REV:D 13.04.01 AS PER DSI9590
REV:E DD VERF:JLM IPP REV:E AS PER DSI9590 REV F JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	5/22/19	5/22/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3	02	
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

10-24-2019



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Container No: S225811



Part: D350-567-141

Job No: 193724

Serial No/Batch: S225811

Revision: G

Inspector:

Exp Date:

Instructions: TC STC SH92-16 Issue 6 FAA STC SH989NE

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120 QC 4	1 pcs	5/22/19	0.00 0.00	Packaging 1 - 31		
				Packaging 1 - 32		
				Packaging 1 - 33		
				Packaging 1 - 34		
				Packaging 1 - 35		
				Packaging 1 - 36		
				QC 4 - 28		
QC 4 - 58				QC 4 - 58		
				QC 4 - 69		
				QC 4 - 9		
				QC 4 - 46	DAS 78 9-89	OCT 2 2019
				QC 4 - 68		
130 Packaging 3-1 - Stock - B4B	1 pcs	5/22/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B	DAS 78 9-89	OCT 2 4 2019
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B	DAS 21 9-89	OCT 2 4 2019
				Packaging 3 - 36 - B4B		
135 DC - 1 - B4B	1 pcs	5/22/19	0.00 0.00	DC - 1 - B4B		
				DC - 2 - B4B		
140 QC 21 - FG	1 pcs	5/22/19	0.00 0.00	QC 21 - FG - 21		
				QC 21 - FG - 70		
				QC 21 - SA - 53		

Part Op 110 - Pick Kit

Descriptions: 120 - QC4- 100% Inspect kits for completeness

130 - Identify and pack for shipping as per PPP D350-567-141 Location:FG033

135 - Photocopy bluefile & type labels per PPP D350-567-141 CHG004

140 - QC21- Final Inspection - Work Order Release

PKC

PHG

Master Unit No: 010805

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A ✓	Bolt (ST3S0)	7 Ea (7 ea) ✓	110-Packaging 1 - Pick Kit	S158308 ✓
AN525-10R6 ✓	Screw (ST329)	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	FH 137307 ✓
AN525-832R7	Screw (ST328)	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	S143221 ✓
D3802-1	Window Seal (\$ Per Foot) (ST416)	2 ft (2 ea) (ok)	110-Packaging 1 - Pick Kit	S177983 ✓
D4434-041	Fwd Bracket Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S221922
D4434-047	Cover Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S193641
D4435-045 ✓	T/R Bellcrank Cover Assembly (ST620)	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	S155550 ✓
D4435-9 ✓	Bracket (ST091)	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	S144007 ✓
D4436-041	Aft Bracket Assembly (QC 520)	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	S219769
D4441-1	Rubber Seal	2 ft (2 ea) (ok) ST422	110-Packaging 1 - Pick Kit	S092167 ✓
MS21042L06 ✓	Nut ST303	7 Ea (7 ea) ✓	110-Packaging 1 - Pick Kit	S151591 ✓
MS21042L08 ✓	Nut ST303	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	S157102 ✓
MS21042L3 ✓	Nut ST303	5 Ea (5 ea) ✓	110-Packaging 1 - Pick Kit	S149299 ✓
MS21059L3 ✓	Nut Plate ST301	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	S163612 ✓
MS35206-229	Screw ST271	7 Ea (7 ea) ✓	110-Packaging 1 - Pick Kit	S143702 ✓
NAS1149F0332P	Washer ST262	12 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	S167104 ✓
NAS1149FN616P	Washer ST263	14 Ea (14 ea) ✓	110-Packaging 1 - Pick Kit	S144987 ✓
NAS1149FN816P	Washer ST263	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	F117316-25 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-3A	7	271	0
	AN525-10R6	2	365	0
	AN525-832R7	2	159	0
	D3802-1	2	38	0
	D4434-041	1	1	0
	D4434-047	1	2	0
	D4435-045	1	4	0
	D4435-9	2	27	0
	D4436-041	1	1	0
	D4441-1	2	364	0
	MS21042L06	7	200	0
	MS21042L08	2	1,148	0
	MS21042L3	5	3,443	0
	MS21059L3	2	327	0
	MS35206-229	7	165	0
	NAS1149F0332P	12	5,239	0
	NAS1149FN616P	14	611	0
	NAS1149FN816P	2	193	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ Scrap ☐ ☐ Use-as-is ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐		Date: _____ Sequence #: _____ QTY Affected: _____		MR8 (QS1042)	
Description Work Order Deviation		Disposition		Completed By					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ Other/Details: _____		Power Loss/Surge ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ Positioned Wrong ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐					
				Lead hand / Supervisor					
				QC / QA Coordinator					

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	